

Work Order ID 121141

June-16-14 1:19:35 PM

121141

Page 1

Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Inboard Bracket Assembly
Start Date: 6/16/14 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 6/16/14 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 14-06-18 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5076	A ✓

110 0.00
110 6 FF JAN 2 7 2015
Packaging Memo 0.00
Packaging

120 0.00
120 6 FF JAN 2 7 2015
Small Fab Memo 0.00
Small Fab 1-Assemble as per dwg, do not install grommets and rubber seal.

130 0.00
130 ⑥ DAS
QC Memo 38
Quality Control 9-89
JAN 2 8 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							2588
140									
Powdercoat	Memo 11/27892	0.00							
Powder Coating	*** MASK NUT PLATE HOLES PER DWG ***								
	START TIME: 1:10								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 1:40								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160									
Small Fab	Memo	0.00							
Small Fab	Install rubber seals and grommets.								
	3M 1300 batch: 131012								

6 0 15-1-29

6X 15/02/0236 9-89

6 FF FEB 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

FEB 03 2015

180	Identify as per dwg & Stock Location: SH36	0.00							
180									
Packaging	Memo	0.00							
Packaging									

DAS
66
8-89

FEB 18 2015

190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

15/2/18

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

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Page 1

Work Order ID: 121141

121141

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.04.01 PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-9 *D4434-9* Bracket		Manufactured	No			1110	Each	4.0000	1	6			
					127631				**	6	FF	JAN 27 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				4					
					115131			4					
D4441-1 *D4441-1* Rubber Seal		Manufactured	No				f	52.3300		4			
									**		FF	FEB 03 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				52.33					
					86185			52.33		4			
D4441-1 *D4441-1* Rubber Seal		Manufactured	No				f	52.3300		3			
									**		FF	FEB 03 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				52.33					
					86185			52.33		3			
D4441-1 *D4441-1* Rubber Seal		Manufactured	No				f	52.3300		5			
									**		FF	FEB 03 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				52.33					
					86185			52.33		5			

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

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Page 2

Work Order ID: 121141

121141

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 6.00

Required Qty: 6.00

D4441-1 Manufactured No

52.3300

4

D4441-1

**

FF

FEB 03 2015

Rubber Seal

Location

Loc Qty

Loc Code

ST407

52.33

86185

52.33

4

D5076-1 Manufactured No

110

Each

0.0000

1

6

D5076-1

**

6

FF

JAN 27 2015

Bracket

D5076-3

Manufactured No

110

Each

0.0000

1

6

D5076-3

**

6

FF

JAN 27 2015

Bracket

D4435-041

Manufactured No

110

Each

6.0000

1

6

D4435-041

**

FF

FEB 03 2015

Bracket Assembly

Location 128397

Loc Qty

Loc Code

ST107

6

115926

6

5

1

D4441-1 Manufactured No

52.3300

1

D4441-1

**

FF

FEB 03 2015

Rubber Seal

Location

Loc Qty

Loc Code

ST407

52.33

86185

52.33

12

D4441-1 Manufactured No

f

52.3300

2

D4441-1

**

FF

FEB 03 2015

Rubber Seal

Location

Loc Qty

Loc Code

ST407

52.33

86185

52.33

2

June-16-14 1:19:35 PM

Shop Packet Print

Page 2

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FAULT CATEGORY

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D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 6.00

Required Qty: 6.00

D4440-1 Manufactured No

160 Each 50.0000 1 6

D4440-1

Grommet

**

FF

FEB 03 2015

Location

Loc Qty

Loc Code

GA 127230
120257

50
50

6

AN525-832R6

Purchased No

110 Each 146.0000 3 18

AN525-832R6

Screw

**

FF

FEB 03 2015

Location

Loc Qty

Loc Code

GA 130466
125303

65
65

18

ST344

81

m127059

81

MS20426AD3-3

Purchased No

110 Each 5,645.000 14 84

MS20426AD3-3

RIVET

**

FF

JAN 27 2015

Location

Loc Qty

Loc Code

ST334

344

123352

344

ST553

5301

M128754

5301

84

MS20470AD4-3

Purchased No

110 Each 4,481.000 15 90

MS20470AD4-3

Rivet - Universal Head

**

FF

JAN 27 2015

Location

Loc Qty

Loc Code

GA

1359

1642

24

2193

1335

90

ST335

3122

2193

3122

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Shop Packet Print

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Training											
Transport											
Unapproved											

FAULT CATEGORY							
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube		General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function		☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

Picklist Print

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Work Order ID: 121141

121141

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 6.00

Required Qty: 6.00

MS21075L08

Purchased

No

110

Each

350.0000

7

42

X *MS21075I 08*

ANCHOR NUT

**

FF

JAN 27 2015

Location

Loc Qty

Loc Code

α ST318 126274
M128635
M128813

350
200
150

α 128199

11

25+6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY							
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube		General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function		☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	